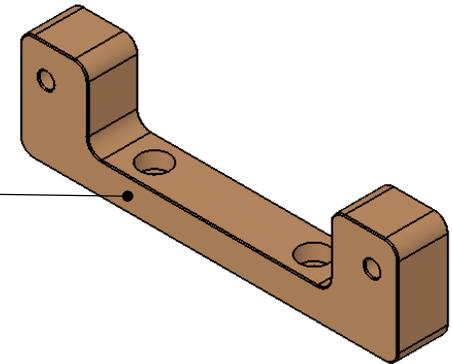


NOTES CONTINUED:

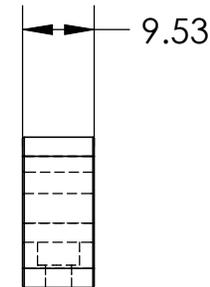
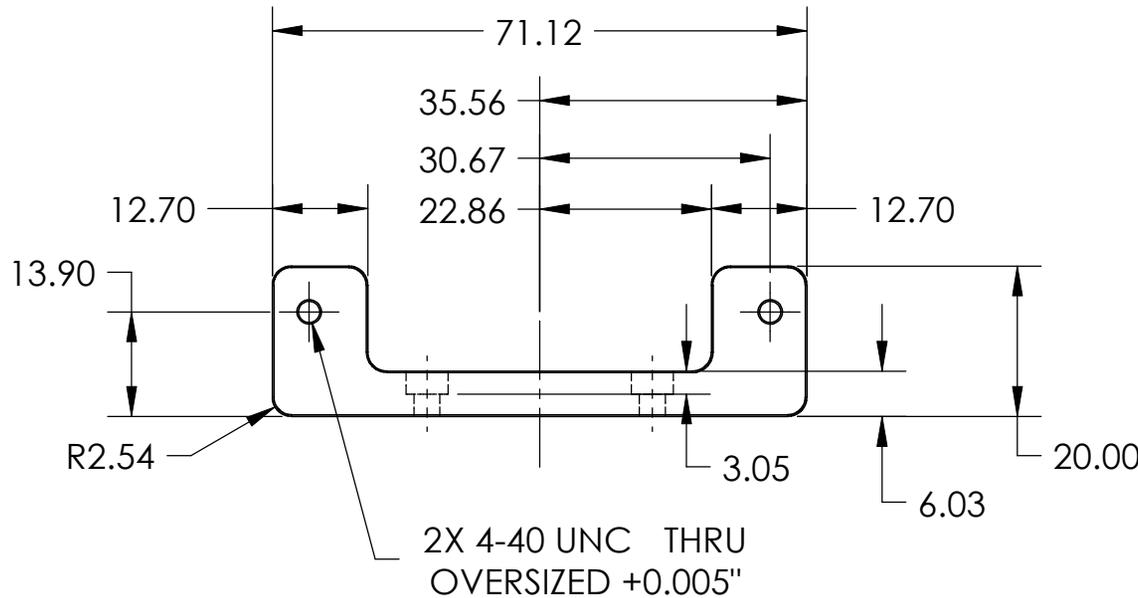
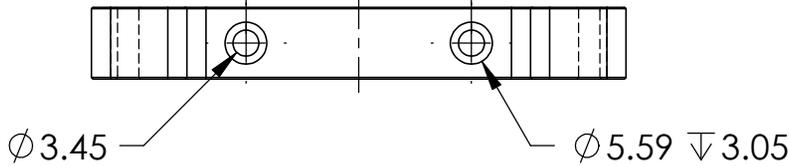
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



15.00 15.00



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:
.XX ± .10
.XXX ± .010

ANGULAR ± 0.5°

- 1. INTERPRET DRAWING PER ASME Y14.5-1994.
- 2. REMOVE ALL SHARP EDGES, R.02 MIN.
- 3. DO NOT SCALE FROM DRAWING.
- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL PEEK FINISH 32 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM ISC

NEXT ASSY Tip-Tilt Structure

PART NAME		Tip-Tilt DSUB Bracket	
DESIGNER	BJJ Slagmolen	15 Nov 2009	SIZE
DRAFTER	BJJ Slagmolen	28 Oct 2010	DWG. NO.
CHECKER			D1001484
APPROVAL			REV. v1
SCALE: 1:1		PROJECTION:	SHEET 1 OF 1